

A TURBINE BLADE**Cross Reference to Related Application**

This application claims benefit of priority under 35USC §119
5 to Japanese Patent Applications No. 2003-159175, filed on June 4,
2003, the entire contents of which are incorporated by reference
herein.

BACKGROUND OF THE INVENTION10 **1. Field of the Invention**

The present invention relates to a turbine blade to be installed into a female dovetail of a turbine disk of an aircraft engine.

2. Description of the Related Art

15 The constitution of a typical turbine blade to be installed into a female dovetail of a turbine disk of an aircraft will be described below.

20 A typical turbine blade includes a blade airfoil as a blade base, one side of the blade airfoil being a convex suction surface and the other side of the blade being a concave pressure surface. A platform is integrally molded on the hub side (at the base end portion) of the blade and recesses are formed respectively on both sides of the platform. A front seal fin protruding forward is formed at the front end of the platform and a rear seal fin protruding 25 backward is formed at the back end of the platform.

25 A male dovetail is integrally disposed on the hub side (at the base end portion) of the platform, the dovetail has an engagement portion able to engage with a female dovetail of a turbine disk, and the engagement portion is usually formed by grinding, whereby, 30 a jig is used for grinding, and one side of the platform can be engaged against a platform-locating portion of the jig.

The manufacturing process of the typical turbine blade will

be described below. The greater part of the turbine blade with the engagement portion remaining unfinished (an unfinished turbine blade) is molded by casting. Next, the unfinished turbine blade is located in the jig so as to make the dovetail axial direction perpendicular to the repulsive force due to work-resistance during grinding, by letting the pressure surface of the blade airfoil supported with a support portion of the jig. Further, setting of the unfinished turbine blade onto the jig is completed by pressing the pressure surface of the blade airfoil against the location portion by means of a clamp of the jig. Then, the turbine blade is finished by forming the engagement portion along the dovetail axial direction by grinding.

SUMMARY OF THE INVENTION

In order for the blade airfoil to be disposed obliquely against the engine axial direction of the aircraft engine, both sides of the platform are angled to the dovetail axial direction of the engagement portion. Consequently, during formation of the engagement portion along the dovetail axial direction by grinding, a component of a force that may cause a displacement of the blade airfoil from the jig is generated. Therefore, there is a problem in that a machining tolerance of the engagement portion is degraded, lowering the quality of the turbine blade, because the unfinished turbine blade is displaced from the jig owing to an increase in the magnitude of the component of a force during grinding.

According to the present invention the unfinished turbine blade is never displaced from the jig, forming an engagement portion with tight machining tolerance, thus enhancing the quality of the turbine blade.

According to a first technical aspect of the present invention, a turbine blade to be installed into an engaged member of a turbine disk of an aircraft engine is characterized in that it comprises

a blade airfoil, one side of which having a convex suction surface and the other side having a concave pressure surface; a platform integrally molded on the hub side of the blade wherein a recess is formed on one side of the platform; a front seal fin formed
5 protruding forward at the front end of the platform; and a rear seal fin formed protruding backward at the back end of the platform, an engagement member integrally molded on the hub side of the platform wherein the engagement member has a engagement face which is able to be engaged with the engaged member of turbine disk and is formed
10 by grinding, a front engagement member integrally molded in the vicinity of a base portion of the front seal fin wherein the front engagement member has a front engagement face able to engage with a front locating portion of a jig to be used for the grinding, and the front engagement face located back from a virtual plane including
15 one side of the platform, a front wall integrally molded in the vicinity of the base portion of the front seal fin wherein the front wall surrounds a front side-edge portion of the front engagement member, a rear engagement member integrally molded in the vicinity of a base portion of the rear seal fin wherein the rear engagement
20 member has a rear engagement face able to engage with a rear locating portion of the jig, and the rear engagement face located back from the virtual plane, and a rear wall integrally molded in the vicinity of the base portion of the rear seal fin, where the rear wall surrounds a rear side-edge portion of the rear engagement member, wherein
25 an end face of the front wall and an end face of the rear wall are respectively configured to be coplanar with the virtual plane.

According to a second technical aspect of the present invention, the turbine blade is characterized in that the front engagement face and the rear engagement face are respectively configured to
30 be substantially parallel to the longitudinal direction of the engagement member.

According to a third technical aspect of the present invention,

the turbine blade is further characterized in that the spacing between the front edge of the front engagement face and the rear edge of the rear engagement face are configured to be longer than the longitudinal length of the engagement member.

- 5 According to a fourth technical aspect of the present invention, the turbine blade is further characterized in that the depth that the front engagement face is located back from the virtual plane and the depth that the rear engagement face is located back from the virtual plane are respectively configured to be in a range of
10 less than or equal to 0.7 mm.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig.1 shows a turbine blade according to an embodiment of the present invention;

- 15 Fig.2 is an enlarged view of the arrowed portion II in Fig.1;
Fig.3 shows a state where the turbine blade according to the embodiment of the present invention is set on a jig;
Fig.4 is a schematic view of the arrowed portion IV in Fig.3;
and
20 Fig.5 shows a state where the turbine blade according to the embodiment of the present invention is installed into a female dovetail of a turbine disk.

DESCRIPTION OF THE PREFERRED EMBODIMENT

- 25 An embodiment of the present invention will be described below referring to Fig.1 to Fig.5. Fig.1 shows a turbine blade according to an embodiment of the present invention; Fig.2 is an enlarged view of the arrowed portion II in Fig.1; Fig.3 shows a state where the turbine blade according to the embodiment of the present invention
30 is set on a jig; Fig.4 is a schematic view of the arrowed portion IV in Fig.3; and Fig.5 shows a state where the turbine blade according to the embodiment of the present invention is installed into a female

dovetail of a turbine disk. Herein, "front and rear (or back)" refers to right hand side and left hand side in Fig.1 and Fig.2, and refers to left hand side and right hand side in Fig.4.

As shown in Figs.1, 2 and 5, the turbine blade 1 relating
5 to the embodiment of the present invention is one to be installed
into a female dovetail 5 of a turbine disk 3 of a low-pressure turbine
for an aircraft engine and comprises a blade airfoil 7 as a main
body of the turbine blade 1. One side (the front side in Fig.1)
of the blade airfoil 7 is a convex suction surface 7fa and the other
10 side (the back side in Fig.1) of the blade airfoil 7 is a concave
pressure surface 7fb.

A shroud 9 is integrally molded on the tip side (the outer
end portion, the upside in Fig.1) of the blade airfoil 7 and the
shroud 9 has a couple of seal fins 11, 13.

15 A platform 15 is integrally molded on the hub side (the inner
end portion, the downside in Fig.1) of the blade airfoil 7, and
recesses 17, 19 are formed respectively on both sides (the one side
and the other side) the platform 15. Moreover, a front seal fin
21 protruding forward is formed at the front end of the platform,
20 and a rear seal fin 23 protruding backward is formed at the back
end of the platform 15. A so-called shank portion is also included
in the platform.

Further, a male dovetail 25 as an engagement member is
integrally molded on the hub side of the platform 15 and the male
25 dovetail 25 has an engagement groove (an engagement face) 25s which
is able to be engaged with an engaged protrusion (an engaged portion)
5b of the female dovetail 5 as an engaged member, and the engagement
groove 25s is formed by grinding.

A front engagement member 27 is integrally molded within the
30 recess 17 in the vicinity of a base portion of the front seal fin
21 and the front engagement member 27 has a front engagement face
27f. Further, as shown with diagonal lines in Fig.2, a thin front

wall Wf surrounding a front side-edge portion of the front engagement member 27 is integrally molded in the vicinity of the base portion of the front seal fin 21.

Moreover, a rear engagement member 29 is integrally molded
5 within the recess 17 in the vicinity of a base portion of the rear seal fin 23 and the rear engagement member 29 has a rear engagement face 29f. Further, as shown with diagonal lines in Fig. 2, a thin rear wall Wr, which surrounds a rear side-edge portion of the rear engagement member 29, is integrally molded in the vicinity of the
10 base portion of the rear seal fin 23.

As shown in Fig. 3 and Fig. 4, the front engagement face 27f of the front engagement member 27 is able to be engaged by a front locator pin 33 of a jig 31 to be used for the grinding, and the rear engagement face 29f of the rear engagement member 29 is able
15 to be engaged against a rear engage pin 35 of the jig 31. Moreover, the front engagement face 27f of the front engagement member 27 and the rear engagement face 29f of the rear engagement member 29 are respectively configured to be located slightly back from a virtual plane VF including one side of the platform 15 and also to be
20 substantially parallel to the dovetail axial direction (longitudinal direction) of the male dovetail 25. Particularly, the distance (depth) of which the front engagement face 27f is located back from the virtual plane VF and the distance (depth) of which the rear engagement face 29f is located back from the virtual plane
25 VF are respectively configured to be in a range of less than or equal to 0.7 mm. In other words, each of the front engagement face 27f of the front engagement member 27 and the rear engagement face 29f of the rear engagement member 29 has a recess in a range of less than or equal to 0.7 mm. Further, the spacing between the
30 front edge of the front engagement face 27f and the rear edge of the rear engagement face 29f are configured to be longer than the length of the male dovetail 25 in the dovetail axial direction.

An end face of the front wall Wf and an end face of the rear wall Wr are respectively configured to be coplanar with the virtual plane VF.

The jig 31 includes the front locator pin 33 and a rear locator pin 35 as well as a locating roller 37 for locating the suction surface 7fa near the tip of the blade airfoil 7, a locating pin 41 for clipping the male dovetail 25 at the rear side thereof and a clip 39 for clipping the male dovetail 25 at the front side thereof, a clamp 45 for pressing the pressure surface 7fb near the hub of 10 the blade airfoil 7 downward via a rubber pad 43, an engagement roller 47 able to be engaged against the back end of the shroud 9, a contact bolt 49 able to be contacted with the front end of the shroud 9.

The operation (mainly manufacturing of the turbine blade 1) 15 of an embodiment of the present invention will be described below. The greater part of the turbine blade 1, with machining portions of the engagement groove 25s and the shroud 9 remaining unfinished (an unfinished turbine blade 1'), is molded by casting. Since the vicinity of base portion of the front seal fin 21 is configured 20 to be thicker in consideration of the strength of the fin, the front engagement member 27 and the front wall Wf are molded utilizing the thicker portion. Also, since the vicinity of base portion of the rear seal fin 23 is configured to be thicker in consideration of the strength of the fin, the rear engagement member 29 and the 25 rear wall Wr are molded utilizing the thicker portion.

Since each of the front engagement face 27f and the rear engagement face 29f has a recess in a range of less than or equal to 0.7 mm, casting defects do not easily occur in the vicinity of the front engagement face 27f and the rear engagement face 29f. 30 After molding the greater part of the turbine blade 1, the machining portion of the shroud 9 is operated by appropriate machining.

Next, the front engagement face 27f of the front engagement

member 27 and the rear engagement face 29f of the rear engagement member 29 are engaged by the front locator pin 33 of the jig 31 and the rear locator pin 35 of the jig 31 respectively, and the suction surface 7fa of the blade airfoil 7 is made to be located 5 with the locating roller 37 of the jig 31. Thereby, the unfinished turbine blade 1' can be located in the jig 31 so as to make the dovetail axial direction perpendicular to the repulsive force due to work-resistance during grinding. Besides, location of the unfinished turbine blade 1' relative to the jig 31 in the machining 10 direction is also performed by engaging the back end of the shroud 9 with the engagement roller 47 of the jig 31 to make the contact bolt 49 contact with the front end of the shroud 9.

Further, the male dovetail 25 is located at the rear end of the dovetail 25 with a locating pin 41 of the jig 31, and clipped 15 with a clip 39 at the front end of the dovetail 25, and the pressure surface 7fb near the hub of the blade airfoil 7 is pressed downward with a clamp 45 of the jig 31 via a rubber pad 43. Thereby, the setting of the unfinished turbine blade 1' onto the jig 31 is completed. Since the spacing between the front edge of the front engagement 20 face 27f and the rear edge of the rear engagement face 29f has been configured to be longer than the longitudinal length of the engagement member, the loaded state of the unfinished turbine blade 1' on the jig 31 is further stabilized.

Then, the manufacturing of the turbine blade 1 is finished 25 by forming the engagement groove 25s along the dovetail axial direction by the grinding. Since the front engagement face 27f of the front engagement member 27 and the rear engagement face 29f of the rear engagement member 29 are respectively configured to be substantially parallel to the dovetail axial direction, only 30 the repulsive force, which is due to work resistance and is perpendicular to the dovetail axial direction, will occur on the front engagement face 27f and the rear engagement face 29f in a

case where the engagement groove 25s is formed along the dovetail axial direction by grinding. Therefore, substantially no repulsive force, which displaces the longitudinal direction of the dovetail, will occur.

5 In addition to the operation described above, the front engagement face 27f of the front engagement member 27 and the rear engagement face 29f of the rear engagement member 29 are respectively configured to be located slightly back from the virtual plane VF including one side of the platform 15. And also, the end face of
10 the front wall Wf and the end face of the rear wall Wr are respectively configured to be coplanar with the virtual plane VF. Therefore, the spacing between adjacent turbine blades 1 will not be widened locally when a number of turbine blades 1 are installed into the turbine disk 3.

15 According to the embodiment of the present invention, since only the repulsive force being perpendicular to the dovetail axial direction will occur on the front engagement face 27f and the rear engagement face 29f in a case where the engagement groove 25s is formed along the dovetail axial direction by grinding, enhancement
20 in quality of the turbine blade 1 can be achieved because the unfinished turbine blade 1' will not be displaced from the jig 31 during grinding, thus preventing degradation of the machining tolerance of the engagement groove 25s. Particularly, since the set state of the unfinished turbine blade 1' is further stabilized,
25 a further improvement in quality of the turbine blade 1 can be achieved by enhancing the machining tolerance of the engagement groove 25s.

According to the embodiment of the present invention, the front engagement member 27 and the front wall Wf are molded utilizing the thicker portion which is configured to be thicker in consideration
30 to the strength of the front seal fin 21, and the rear engagement member 29 and the rear wall Wr are molded utilizing the thicker portion which is configured to be thicker in consideration to the

strength of the rear seal fin 23. Therefore, the addition of the front engagement member 27, the front wall Wf, the rear engagement member 29 and the rear wall Wr to the components of the turbine blade 1 does not cause any increase in a weight of the turbine blade
5 1.

Further, since casting defects can do not easily occur in the vicinity of the front engagement face 27f and in the vicinity of the rear engagement face 29f, the occurrence of rejects of the turbine blade 1 can be reduced.

10 Moreover, since the spacing between adjacent turbine blades 1 is not be extended locally when a number of turbine blades 1 are installed into the turbine disk 3, a flow of high-temperature gas from the main stream toward the center of the engine can be prevented during the operation of the aircraft engine to increase the engine
15 efficiency of the aircraft engine and to avoid temperature increase of the turbine disk 3.

Further, the present invention should not be limited to the description of the above embodiment of the invention, but it can be applicable in various modes through causing the appropriate
20 conversion thereof, for example, an application of the turbine blade 1 to a turbine blade for a high-pressure turbine of the aircraft engine, etc.

Modifications and variations of the embodiments described above will occur to those skilled in the art, in light of the teachings.
25 The scope of the invention is defined with reference to the following claims.